



Ok to Enter

4/28/04

AN

"CLEAN" COPY OF THE AMENDED SPECIFICATION

METHOD FOR MANUFACTURING ZIPPER WITHOUT SHIFT IN INJECTION MOLDING

Field of the invention

The present invention relates to zippers, and particularly to a method for manufacturing a zipper without shift in injection molding.

Background of the invention

The engaging pieces of prior art zippers, especially lower engaging pieces, possibly shift in the manufacturing process since the zipper strips cannot be precisely located on the upper and lower engaging piece molds so that the upper and lower engaging pieces cannot be precisely positioned in the molds. Therefore, the upper and lower engaging pieces have bad appearance.

With reference to Figs. 1 and 2, the prior art way for manufacturing a zipper is illustrated. The prior art zipper has a left and a right zipper strips 90. Each zipper strip 90 has zipper teeth 91 thereon. A part of the zipper teeth 91 is scraped with a predetermined length. Then two layers of films are melt and then coated on the two sides of the zipper strips 90. Then the two layers of films are punched with notches 93 which are opened. In the punching process, the connecting strip 901 is also punched. Then, lower engaging pieces 94, 95 are injection-molded on the notches, and the upper engaging pieces 96, 97 at the upper side of the films 92 are injected.